

WHAT IS CLAIMED IS:

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1. A resin composition which comprises a thermoplastic elastomer composition comprising 100 parts by weight of a (a1) hydrogenated block copolymer which is obtained by hydrogenating a block copolymer consisting essentially of at least one polymer block composed principally of a vinyl aromatic compound and at least one polymer block composed principally of a conjugated diene compound, which has a weight average molecular weight of at least 200,000, in which the at least one polymer block composed principally of a vinyl aromatic compound is polystyrene, and in which the content by weight of the polystyrene moiety that is contained in the hydrogenated block copolymer is in the range of 20 to 40%; 100 to 200 parts by weight of a (b1) non-aromatic rubber-softening agent having a kinematic viscosity at 40°C of at least 300 mm<sup>2</sup>s<sup>-1</sup>; and 10 to 50 parts by weight of a (c1) modified polyolefinic resin, said resin composition having a hardness as measured in accordance with JIS K6253 with a durometer of type A being at most 50 degrees and a compression set as measured in accordance with JIS K6262 after being allowed to stand at 70°C under a compression ratio of 25% for 22 hours being at most 50%.

2. The resin composition according to Claim 1, wherein the (c1) modified polyolefinic resin is that which has a functional group having an absorption band at a wave number in the range of 1500 to 2000 cm<sup>-1</sup> in the infrared absorption spectrum thereof.

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3. The resin composition according to Claim 2, wherein the (c1) modified polyolefinic resin is a resin which is produced by

modifying a polyolefinic resin composed principally of polypropylene with an unsaturated carboxylic acid or a derivative thereof.

4. The resin composition according to Claim 3, wherein the unsaturated carboxylic acid is maleic anhydride.

5. A gasket material which comprises the resin composition as set forth in Claim 1.

6. A gasket integrated with a metal, which is formed by molding the gasket material as set forth in Claim 5.

7. A hard disc gasket which comprises the gasket integrated with a metal as set forth in Claim 6.

8. A thermoplastic elastomer composition comprising 100 parts by weight of a (a2) hydrogenated block copolymer which is obtained by hydrogenating a block copolymer consisting essentially of at least one polymer block composed principally of a vinyl aromatic compound and at least one polymer block composed principally of a conjugated diene compound, which has a weight average molecular weight of at least 200,000, in which the at least one polymer block composed principally of a vinyl aromatic compound is polystyrene and in which the content by weight of the polystyrene moiety that is contained in the hydrogenated block copolymer is in the range of 20 to 40%; 100 to 200 parts by weight of a (b2) non-aromatic rubber-softening agent having a kinematic viscosity at 40°C of at least 300 mm<sup>2</sup>s<sup>-1</sup>; 10 to 50 parts by weight of a (c2) modified hydrogenated block copolymer obtained by hydrogenating a block copolymer in which a functional group is imparted to a block copolymer consisting essentially of at least one polymer block composed principally

of a vinyl aromatic compound and at least one polymer block composed principally of a conjugated diene compound; and 0 to 20 parts by weight of a (d2) compound composed principally of a crystalline polyolefin, said thermoplastic elastomer composition having a hardness as measured in accordance with JIS K6253 with a durometer of type A being at most 50 degrees and a compression set as measured in accordance with JIS K6262 after being allowed to stand at 70°C under a compression ratio of 25% for 22 hours being at most 50%.

9. The thermoplastic elastomer composition according to Claim 8 wherein the (c2) modified hydrogenated block copolymer is that which has a functional group having an absorption band at a wave number in the range of 1500 to 2000  $\text{cm}^{-1}$  in the infrared absorption spectrum thereof.

Sub A4 10. The thermoplastic elastomer composition according to Claim 9, wherein the (c2) modified hydrogenated block copolymer is that which is modified with an unsaturated carboxylic acid or a derivative thereof.

11. The thermoplastic elastomer composition according to Claim 10, wherein the unsaturated carboxylic acid is maleic anhydride.

12. A gasket material which comprises the thermoplastic elastomer composition as set forth in Claim 8.

12 13. A gasket integrated with a metal, wherein the gasket material as set forth in Claim 12 is molded into a gasket integrated with a metallic cover or a metallic frame.

10 13 14. The gasket integrated with a metal according to Claim 13, which is used as a gasket for a hard disc apparatus.

15. A composite molded body that is formed by integrating through thermally fusing adhesion, a metallic sheet laminated with a thermoplastic resin having a hardness as measured in accordance with JIS K6253 with a durometer of type A of at least 50 degrees; and a thermoplastic elastomer composition having a hardness as measured in accordance with JIS K6253 with a durometer of type A being at most 60 degrees and a compression set as measured in accordance with JIS K6262 after being allowed to stand at 70°C under a compression ratio of 25% for 22 hours being at most 50%.

16. The composite molded body according to Claim 15, wherein the thermoplastic resin is at least one species selected from the group consisting of polyethylene, polypropylene and polystyrene.

17. The composite molded body according to Claim 15, wherein the thermoplastic resin laminate has a thickness of at most 100  $\mu m$ .

18. The composite molded body according to Claim 15, wherein the thermoplastic elastomer composition comprises at least one species selected from the group consisting of styrenic thermoplastic elastomers, olefinic thermoplastic elastomers and urethanic thermoplastic elastomers.

19. The composite molded body according to Claim 15, wherein the thermoplastic elastomer composition comprises 100 parts by weight of a (a3) hydrogenated block copolymer which is obtained by hydrogenating a block copolymer consisting essentially of polystyrene block and at least one polymer block composed principally of a conjugated diene compound, in which the content

by weight of the polystyrene moiety that is contained in the hydrogenated block copolymer is in the range of 20 to 40% ; 100 to 500 parts by weight of a (b3) non-aromatic softening agent having a kinematic viscosity at 40°C of at least 300 mm<sup>2</sup>s<sup>-1</sup>; and 5 to 100 parts by weight of a (c3) polyolefinic hydrocarbon resin.

20. The composite molded body according to Claim 15, which is a gasket fitted to a cover.

21. The composite molded body according to Claim 15, wherein the composite molded body is a gasket fitted to a cover, and the metal surface side of the laminated metallic sheet forms a sealing surface.

22. A process for producing the composite molded body as set forth in Claim 15, comprising placing a metallic sheet which has a prescribed shape and which is laminated on at least one side thereof with a thermoplastic resin, and injection molding a thermoplastic elastomer composition onto at least one part of the surface laminated therewith to integrate the metallic sheet and the thermoplastic elastomer composition.

23. A process for producing a composite molded body of a resin and metal which comprises subjecting part or all of the surface of a metallic part that comes into contact with a resin portion to a corona treatment or a plasma treatment, thereafter placing the metallic part thus treated in a mold, and then injecting a thermoplastic elastomer composition onto the surfaces of the metallic part placed in the mold to form the resin portion.

24. The process for producing a composite molded body of a resin and metal according to Claim 23, wherein the thermoplastic elastomer composition comprises 100 parts by weight of a (a4) hydrogenated block copolymer which is obtained by hydrogenating a block copolymer consisting essentially of at least one polymer block composed principally of a vinyl aromatic compound and at least one polymer block composed principally of a conjugated diene compound, which has a weight average molecular weight of at least 150,000, in which the at least one polymer block composed principally of a vinyl aromatic compound is polystyrene and in which the content by weight of the polystyrene moiety that is contained in the hydrogenated block copolymer is in the range of 20 to 40%; 50 to 200 parts by weight of a (b4) non-aromatic rubber-softening agent having a kinematic viscosity at 40°C of at least 300 mm<sup>2</sup>s<sup>-1</sup>; and 5 to 50 parts by weight of a (c4) polyolefinic resin composed principally of polypropylene, said thermoplastic elastomer composition having a hardness as measured in accordance with JIS K6253 with a durometer of type A being at most 50 degrees and a compression set as measured in accordance with JIS K6262 after being allowed to stand at 70°C under a compression ratio of 25% for 22 hours being at most 50% .

25. The process for producing a composite molded body of a resin and metal according to Claim 23, wherein the thermoplastic elastomer composition comprises 100 parts by weight of a (a5) hydrogenated block copolymer which is obtained by hydrogenating a block copolymer consisting essentially of at least one polymer block composed principally of a vinyl aromatic compound and at

least one polymer block composed principally of a conjugated diene compound, which has a weight average molecular weight of at least 200,000, in which the at least one polymer block composed principally of a vinyl aromatic compound is polystyrene and in which the content by weight of the polystyrene moiety that is contained in the hydrogenated block copolymer is in the range of 20 to 40%; 100 to 200 parts by weight of a (b5) non-aromatic rubber-softening agent having a kinematic viscosity at 40°C of at least 300 mm<sup>2</sup>s<sup>-1</sup>; and 10 to 50 parts by weight of a (c5) modified polyolefinic resin, said thermoplastic elastomer composition having a hardness as measured in accordance with JIS K6253 with a durometer of type A being at most 50 degrees and a compression set as measured in accordance with JIS K6262 after being allowed to stand at 70°C under a compression ratio of 25% for 22 hours being at most 50%.

26. The process for producing a composite molded body of a resin and metal according to Claim 25, wherein the (c5) modified polyolefinic resin is a polyolefinic resin composed principally of polyethylene or polypropylene, and contains an unsaturated carboxylic acid or a derivative thereof or acrylic acid or a derivative thereof.

27. The process for producing a composite molded body of a resin and metal according to Claim 26, wherein the unsaturated carboxylic acid is maleic anhydride.

28. A composite molded body of a resin and metal, characterized by being produced by the process as set forth in Claim 23.

29. The composite molded body of a resin and metal according to Claim 28, which is a gasket integrated with a cover.

30. A process for producing a gasket integrated with a cover by placing a metallic cover in a mold, and injecting a gasket material composed of a thermoplastic elastomer composition onto the surface of said cover so as to form a gasket portion, characterized in that the thermoplastic elastomer composition is injection cast from a direction different from the direction towards a butt contact surface on the gasket portion upon the use thereof.

31. The process for producing a gasket integrated with a cover according to Claim 30, wherein the thermoplastic elastomer composition is injection cast onto the surface of the cover from the direction towards the rear face of the gasket portion through at least one hole bored in advance in the metallic cover.

32. The process for producing a gasket integrated with a cover according to Claim 30, wherein the thermoplastic elastomer composition is injection cast onto the surface of the cover from the direction towards a side face of the gasket portion.

33. The process for producing a gasket integrated with a cover according to Claim 30, wherein the thermoplastic elastomer composition comprises 100 parts by weight of a (a6) hydrogenated block copolymer which is obtained by hydrogenating a block copolymer consisting essentially of at least one polymer block composed principally of a vinyl aromatic compound and at least one polymer block composed principally of a conjugated diene compound, which has a weight average molecular weight of at least 150,000, in which the at least one polymer block composed principally of a vinyl aromatic compound is polystyrene, and



in which the content by weight of the polystyrene moiety that is contained in the hydrogenated block copolymer is in the range of 20 to 40% ; 50 to 200 parts by weight of a (b6) non-aromatic rubber-softening agent having a kinematic viscosity at 40°C of at least 300 mm<sup>2</sup>s<sup>-1</sup>; and 5 to 50 parts by weight of a (c6) polyolefinic resin composed principally of polypropylene, said thermoplastic elastomer composition having a hardness as measured in accordance with JIS K6253 with a durometer of type A being at most 50 degrees and a compression set measured in accordance with JIS K6262 after being allowed to stand at 70°C under a compression ratio of 25% for 22 hours being at most 50% .

34. The process for producing a composite molded body of a resin and metal according to Claim 30, wherein the thermoplastic elastomer composition comprises 100 parts by weight of a (a7) hydrogenated block copolymer which is obtained by hydrogenating a block copolymer consisting essentially of at least one polymer block composed principally of a vinyl aromatic compound and at least one polymer block composed principally of a conjugated diene compound, which has a weight average molecular weight of at least 200,000, in which the at least one polymer block composed principally of a vinyl aromatic compound is polystyrene, and in which the content by weight of the polystyrene moiety that is contained in the hydrogenated block copolymer is in the range of 20 to 40% ; 100 to 200 parts by weight of a (b7) non-aromatic rubber-softening agent having a kinematic viscosity at 40°C of at least 300 mm<sup>2</sup>s<sup>-1</sup>; and 10 to 50 parts by weight of a (c7) modified polyolefinic resin, said thermoplastic elastomer

composition having a hardness as measured in accordance with JIS K6253 with a durometer of type A being at most 50 degrees and a compression set as measured in accordance with JIS K6262 after being allowed to stand at 70°C under a compression ratio of 25% for 22 hours being at most 50% .

35. The process for producing a composite molded body of a resin and metal according to Claim 34, wherein the (c7) modified polyolefinic resin is a polyolefinic resin composed principally of polyethylene or polypropylene and contains an unsaturated carboxylic acid or a derivative thereof or acrylic acid or a derivative thereof.

36. The process for producing a composite molded body of a resin and metal according to Claim 35, wherein the unsaturated carboxylic acid is maleic anhydride.

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